## \*111791\*

Page 1

January-22-14 10:39:42 AM Accept Item ID: D3584-1 \*N900040100\* Setup Start **Revision ID:** Web **Item Name: Start Qty: 10.00** \*10\* 1/22/14 **Start Date: Cust Item ID:** Required Date: 2/05/14 Req'd Oty: 10.00 \*10\* **Customer:** Reference: Run Start Date: 14-01-22 Tooling: Process Plan: \_\_ML5 Approvals: Date: Stop Date: SPC (Y/N): Date: Sequence ID/ Operation Reject Set Up/ **Tool ID** Tool # Plan Accept Reject Insp. **Work Center ID** Description Code Number Stamp **Run Hours Oty** Oty Draw Nbr **Revision Nbr** D3584 Rev A 100 0.00 < > 10 & 14-1-23 Dec Skidtubes \*100\* Skidtubes 0.00 Memo Skidtubes 1-Cut to Lengh as per Dwg D3584 2-Drill Pillot Holes using DT8960 Drill Jig 3-Open pillots to 1.000" as per Dwg D3584 4-Deburr  $\circ$ 110 QC5- Inspect part completeness to step on W/O 0.00 QC 0.00 Memo Quality Control 120 Chemical Conversion Coat per QSI005 4.1 0.00 mm 14/01/24 \*120\* 0.00 HandFinish Memo Hand Finishing

DQA:			Date:												
						WORK ORDER NON-CONFORMANCE / UPDATE									
QA Closed:			Date:							W	ork Order up	date only			
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Work Orde	٠,				_	Rework	1		Skid-tube Crosstube	<u>_</u>	1	Water Jet	Engineering		
Part N	J۸					Scrap	1		Machining Small Fal		Pro	d. Eng. Coor.	Quality		
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Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector		
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		Centre No	ot Concer	ntric		BOM/Route	$\vdash$	Grain	10614111	<b> </b>	Over/Under	<del> </del>	Set-up		
		Cracks	0011001			Broken/Damage/Defect		Hardwa	are	$\vdash$	Part Incorre	h	Temperature/Cure		
ļ		Crimp/Kir	nk/Ripple	/Wave		Burrs		4	ion Incomplete/Unqualified		Part Lost/Mi	<u> </u>	Weld		
·	Cuffs					Contamination		4 '	tions Incomplete/Unclear	T	Part Moved		Wrong Stock Pulled		
	Crushing					Countersink		4	gned/off center		Positioned V	ــــ Vrong	_ ~		
		Heat Trea	it .			Cut Too Short		Mislab			Power Loss/	Surge	Other		
		Inspection	n Strip in	Tube		Drawing		Misrea	d						
		Marks/Ch	atter			Drill Holes		Off-set							
		Turning S	equence			Finish		Out of	Calibration						
	Wave/Twist in Tube					Fit/Function		Out of	Sequence						

Work Order ID 111791

**44447044** 

January-22-14					Page 2					
Item ID: Revision ID: Item Name:	D3584-1 Web			Accept	*N900	<b>040</b>	100*	Setup	Start Stop	*NS1* *NS2*
Start Date: Required Date Reference:	1/22/14 : 2/05/14	Start Qty: 10.00 Req'd Qty: 10.00	*10* *10*		Cust Item I Customer:	D:				14.17
Approvals:	Process P QC:	lan:	Date:	Tooling: SPC (Y/N):		ate:	· 	Run	Start Stop	*NR1* *NR2*
Sequence ID/ Work Center I  130  *1.20* QC Quality Control		Operation Description QC7-Inspect Chemical C		Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Acc Code Qty		y N	Reject Insp. Number Stamp
140  *1 10* Packaging Packaging		Identify as per dwg & Sto	ock Location:	0.00			T.	P-	14-	1-29
150 *150* QC Quality Control		QC21- Final Inspection -  Memo	Work Order Release	0.00				NLJ	14-00 MCT	<u> 14-01-29</u>

DQA:			Date:		<u>-</u>								TRAGG		
						WORK ORDER NON-CONFORMANCE / UPDATE									
QA Closed:			Date:			Work Order update only									
Work Orde	er:				:	DISPOSITION			AGA	NNST DE	PARTMENT/	PROCESS			
	•			<del></del>	_	Rework	1		Skid-tube Cross	stube		Water Jet	Engineering		
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Root					Desc	ription of work order update	1	nitial	Action		Sign &				
Cause	_	Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector		
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		Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorred		Temperature/Cure		
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	Cuffs					Contamination		1 '	tions Incomplete/Unclear		Part Moved		Wrong Stock Pulled		
	Crushing					Countersink		4	gned/off center		Positioned V	Vrong	<del>-</del>		
Heat Treat						Cut Too Short		Mislab	eled		Power Loss/	Surge	Other		
Inspection Strip in Tube						Drawing		Misrea	d	-					
		Marks/Ch				Drill Holes		Off-set							
		Turning S	equence			Finish		Out of	Calibration						
		Wave/Tw	ist in Tub	oe e		Fit/Function		Out of	Sequence						

**Picklist Print** 

January-22-14 10:38:25 AM

Work Order ID: 111791

\*111791\*

Parent Item:

D3584-1

\*D3584-1\*

Parent Item Name: Web

**Start Date: 1/22/14** 

Required Date: 2/05/14

**Start Qty: 10.00** 

Required Oty: 10.00

**Comments:** 

IPP Rev:A New Issue 07.06.12

EC

Component Item ID/ Replacement Mfg/ **Item Name** Item ID Purch

Bin Primary Item Location

Route Location Seq ID

Unit of Measure Hand

Qty on

Qty per Kit Total

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Qty Issued Date Status **Issued** 

D2963-125

Manufactured

No

Last

110

Each

46.0000

1

Qty

10

Page 1

105 I Beam Extrusion

Location

Loc Qty 46

46

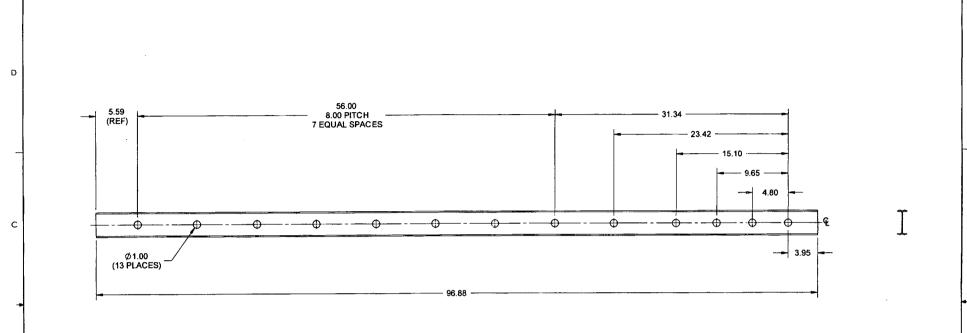
Loc Code

15 DGL A-+23

28673

DQA:			Date:											7	
						WORK ORDER NON-CONFORMANCE / UPDATE									
QA Closed:			Date:			Work Order update only									
Work Orde	er:					DISPOSITION				PROCESS					
	-					Rework			Skid-tube	Crosstube			Water Jet	]	Engineering
Part N	lo.					Scrap			Machining	Small Fab		Prod. Eng. Coor.			Quality
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Root					Desc	ription of work order update		nitial	Act	tion		Sign &			
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	Cracks					1	$\vdash$	4	ire ion Incomplete/U	ngualified		Part Lost/Mi		-	Weld
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111791



D3584-1 WEB

Α	NEW ISS	UE		PH	07.06.08					
REV.			DESCRIPTION	BY	DATE					
DESIG	V	24	DART AEROS	DART AEROSPACE USA, INC.						
DRAW	V	QJ-	PORT HADLOCK, WA							
CHECH	ŒD	W	DRAWING NO.	No.						
MFG. A	PPR.	12	D3584		SHEET 1 OF 1					
APPRO	VED	W	TITLE		SCALE					
DE API	PR.	-#	WEB							
DATE	07.0	6.08	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC.  THIS DOCUMENT S PRIVATE AND CONTECTING, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS  NOT TO BE USED FOR ANY PARPOSE OR COMMANDICATED TO ANY OTHER PERSON WITHOUT							

NOTES:	
NOTES:	
1) MATERIAL:MAKE FROM D2963-125 EXTRUSION	
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1	
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED	)
4) UNITS: INCHES UNLESS OTHERWISE NOTED	
4) UNITS. INCHES UNLESS OTHERWISE NOTED	
5) BREAK SHARP EDGES: 0.010 TO 0.020	
6) IDENTIFICATION: N/A	

7

7) WEIGHT: 5.08 lbs

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DQA:			Date:													
						WORK ORDER NON-CONFORMANCE / UPDATE										
QA Closed:			Date:			Work Order update only										
Work Order	<b>.</b> .					DISPOSITION			AGAIN	/PROCESS						
Work Order	· –					Rework			Skid-tube Crosstu	be	1	Water Jet	Engineering			
Part No	o.					Scrap			Machining Small F	· -	Pro	d. Eng. Coor.	Quality			
	_					Use-as-is			noforming Finishi	_	4	re/Packaging	Other			
NCR No	o					Suspected Unapproved			Large Fab Compos	ite	]	Supplier				
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	→	Centre No	t Concer	ntric	<u> </u>	BOM/Route	<u> </u>	Grain		<u> </u>	Over/Under	<del></del>	Set-up			
-	$\vdash$					Broken/Damage/Defect	<u> </u>	Hardwa			Part Incorred		Temperature/Cure			
	Crimp/Kink/Ripple/Wave					Burrs	$\vdash$	1 '	tion Incomplete/Unqualified	$\vdash$	Part Lost/Mi	issing	Weld			
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